

Date: Monday, 2/4/2008 11:24:06 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHIM
Job Number : 37160	
Estimate Number : 10916	
P.O. Number :	Part Number : D34423
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D3442 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33281	Material :
Written By : <u>JD</u>	Due Date : 2/11/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JD 080204</u>	
Comment : Est. A 05.09.02 New issue KJ/JLM	
est B 07.07.23 waterjet EC verified by: JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.0263 sf(s)/Unit Total : 1.0500 sf(s)  
 304/316 SS 0.032" Sheet  
 batch: 106419 IB 8-2-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3442  
 Dwg Rev: A  
 Prog Rev: A

IB 8-2-5

45

2-Deburr if necessary

08/02/05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-2-5

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counts  
08/02/05 45

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock W5  
 Location: PATD.

08/02/06 45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/02/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:24:06 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 37160

Part Number: D34423

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



45

Comment: FINAL INSPECTION/W/O RELEASE

D 09/02/07

Job Completion



min 2000 12/06

45

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

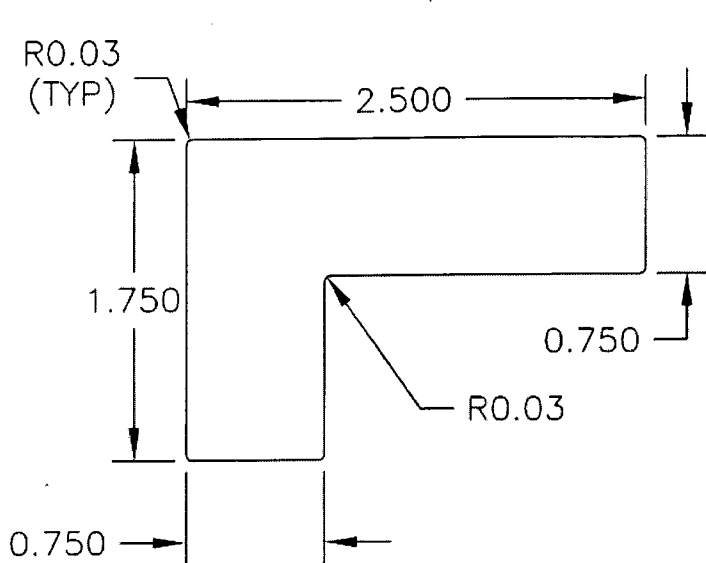
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

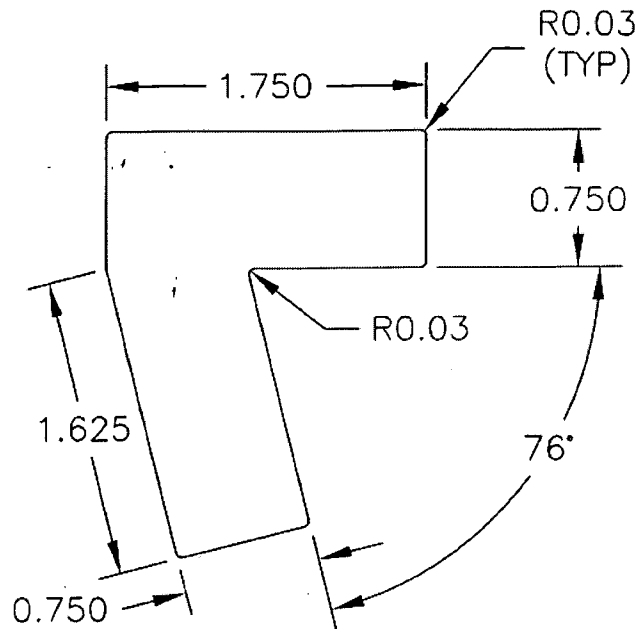
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03		TITLE SHIM	SCALE 1:1
A	05.06.03	NEW ISSUE	



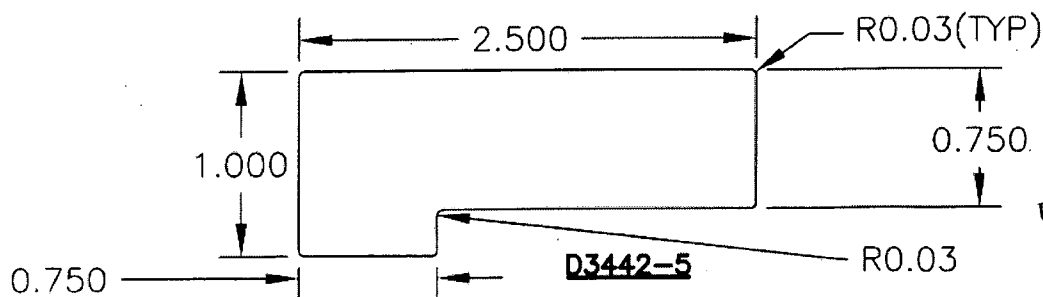
**D3442-1**



**D3442-3**

**D3442-1/-3 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)  
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D3442-5**

**D3442-5 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *37160*

**RELEASED**

*05.08.19* *[Signature]*

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